January 10, 2011 10:45:27 AM

Item ID:

D3438-042

Accept

Setup Start

Stop

Stop



**Revision ID:** 

Item Name:

Step Weldment Assembly

Start Date:

Required Date: 1/21/11

1/10/11

Start Qty: 2.00

Reg'd Qty: 2.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: MF

Date: 11-01-10 Tooling:

Date: \_\_\_\_\_

0.00

SPC (Y/N):

Date:

Date:

Start Run

Reject

**Qty** 



Sequence ID/ Work Center ID

Operation **Description**  Set Up/ **Run Hours**  Tool ID

Tool # Plan Code

Accept **Qty** 

Reject Number

Insp. Stamp

Draw Nbr

**Revision Nbr** 

D3438 Rev A

100

Large Fab

Large Fab

0.00

Large Fab

1-Cut D2244 to 79.63" at 34° as per Dwg D3438□2-Deburr ends□3-Weld one cap, LUG PLATES &MOUNTING ANGLE as per Dwg D3438 using DT8343

4-Grind

Memo

Memo

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

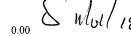
0.00

0.00

a & SEIJOJIB

120

QC5- Inspect part completeness to step on W/O



Memo

Quality Control

<b>Dart</b>	Aeros	pace	Ltd
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W/O:		WORK ORDER CH	WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
							,					
Part No		PAR #· Fault Category:	NCR: Yes	No DO	Δ-	Date:						

QA: N/C Closed: \_\_\_\_\_

Date: \_

Disposition: \_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification		Approval		
DATE STEP		Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	ption Sign & Date		Approval Chief Eng	Approval QC Inspector		
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NOTE: Date & initial all entries

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Resolution:



Page 2

January 10, 2011 10:45:27 AM

Item	ID:
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D3438-042

Accept



Setup Start



**Revision ID:** 

Item Name:

Required Date: 1/21/11

Step Weldment Assembly

**Start Date:** 

1/10/11

Start Qty: 2.00

Req'd Qty: 2.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Tooling:

0.00

0.00

Date:

Run

Start

Reject

Qty

Stop

Stop



Sequence ID/

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

**Tool ID** 

1211.01-20

Tool # Plan

Code

Accept Qty

Reject Number

Insp. Stamp

**Work Center ID** 130

HandFinish Hand Finishing **Operation** Description

Chemical Conversion Coat per QSI005 4.1

140

Quality Control

QC3- Inspect Part Finish

Memo

Memo

0.00

0.00

150

Large Fab Large Fab

Large Fab

Memo

0.00

Weld last cap per dwg D3438 & grind flush

M108436 Alluminum Rad

•									
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				•					
Part No	•	PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A:	Date: _	
Resolution:		esolution:	Disposition	QA: N/C Cld	QA: N/C Closed: Date:				
NCR:		1	WORK ORDE	R NON-CONFORM	ANCE (NCR	)			
DATE	OTED	Description of NC	Corrective Action		Section B		cation	Approval	Approval
DAIL	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sec	tion C	Chief Eng	QC Inspector
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Page 3

January 10, 2011 10:45:28 AM

Item ID:

D3438-042

**Revision ID:** 

Step Weldment Assembly Item Name:

**Start Date:** 

1/10/11

QC:

Start Oty: 2.00

Required Date: 1/21/11

Req'd Qty: 2.00



Date: \_\_\_\_\_

Accept



Setup Start

Stop



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

**Tooling:** Date:

SPC (Y/N):

Date:

Date:

Run

Start



Stop

Sequence ID/ **Work Center ID** 

160

Quality Control

Operation Description

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

170

**Quality Control** 

QC5- Inspect part completeness to step on W/O

180 Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

TOUCH UP ALO.

1-Touch up alodine START TIME: 1-TEMPERATURE: SFINISH TIME:

2 Bl 11-01-20.

Dart .	Aero	space	Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty		Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				• .					
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No <b>DQ</b>	A:	Date:	
Resolution:			Disposition	Disposition: QA: N/C				Date: _	
NCR:			WORK ORE	ER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC		Corrective Action Section B		- Verific	Verification	Approval	Approval
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January 10, 2011 10:45:28 AM



Page 4

Item ID:

D3438-042

Accept



Setup Start

**Revision ID:** 

Item Name:

Required Date: 1/21/11

Step Weldment Assembly

Start Date:

1/10/11

QC:

Start Otv: 2.00

**Reg'd Oty: 2.00** 



**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

Wing Walk as per Dwg 3438 and QSI 005 4.4□Mask off 0.5 each side of D2561

SPC (Y/N):

Set Up/

0.00

Run Hours

Date: Date:

Code

Tool # Plan

Stop

Run

Accept

Qty

Start

Stop



Insp.

Stamp

Sequence ID/ Work Center ID

190

HandFinish

Hand Finishing

Operation Description

HandFinishing

1115790

11/01/21 2 \$

Reject

Otv

Reiect

Number

200

Quality Control

QC3-Inspect Part Finish

0.00

Memo

0.00

Pay 1/01/20 0

210

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

PAP65247

<b>Dart Aerospace L</b>	td
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W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	•	PAR #:	Fault Cate	jory:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date: _	
Resolution:			Disposition	_ Disposition: QA: N/C Closed: Date: _					
NCR:		\	WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
DATE	CTED	Description of NC	NC Corrective Action Section			Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng  Sign & Section C	on C	Chief Eng	QC Inspector		
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January 10, 2011 10:45:29 AM



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Item ID:

D3438-042

Accept

Setup Start



**Revision ID:** 

Step Weldment Assembly Item Name: 1/10/11

QC:

Required Date: 1/21/11

Start Otv: 2.00 Req'd Qty: 2.00

**Cust Item ID:** 

Customer:

Tool ID

Reference:

**Start Date:** 

Approvals:

Process Plan:

Date: Date:

Tooling: SPC (Y/N):

Date:

Date:

Run

Start Stop

Stop



Sequence ID/

Work Center ID

220

Description

Operation

OC21- Final Inspection - Work Order Release

Set Up/ Run Hours

0.00

Tool # Plan

Accept Code Qty

Reject Qty

Reject Number Insp. Stamp.

Memo

0.00

Quality Control

Dart	<b>Aeros</b>	pace	Ltd
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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							<u> </u>					
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date: _				
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ification ection C	Chief Eng	QC Inspector			
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	,						<u>.</u>					

# **Picklist Print**

January 10, 2011 10:45:26 AM

Work Order ID: 65246

Parent Item:

D3438-042

Parent Item Name: Step Weldment Assembly



**Start Date: 1/10/11** 

Required Date: 1/21/11

Page\_

Start Qty: 2.00

Required Qty: 2.00

Comments:	IPP	A□05.05.18	New Issu	e□KJ/JLM□
Component Item ID/	R	eplacement	Mfg/	Bin

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116		Manufactured	No		111/10	100	Each	106.0000	1	2	/. D/.	14	
Ctan Tatanaian	4 SI 11818 BILL 1881								166	7011		//	

Step Extrusion

	Location	Loc	: Oty	Loc Code
	WA		106	
	57850		29	
	. 60307		77	
No		100	Each	11.0000

0000	2	4	JE11.01.	17
------	---	---	----------	----

D2561	
Lug	

Lug			

Location	Lo	c Qty	Loc Code
WA		11	
60096		11	
	100	Each	148.0000

D2673-34

D2564



Manufactured No

Manufactured

148.0000 Each

End Plate

	•
Manufactured	No

Loc Code Location Loc Qty WA 148 57527 59690 147 110 Each 21.0000

Mounting Angle

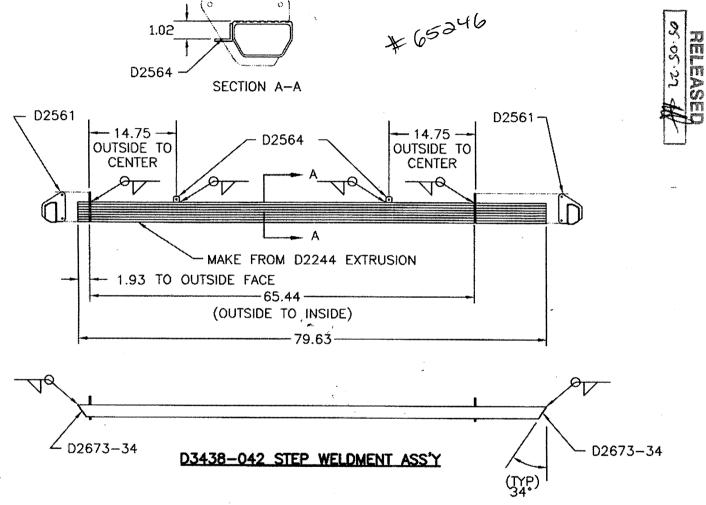
<b>Location</b>	Loc Qty	Loc Code
WA	21	
60097	1	
62951	20	
•		

W/O:		,	W	ORK ORDER CHANG	ES					
DATE	STEP	PRC	OCEDURE CHA	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		PARTIES AND RES								
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										5
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: `	Yes N	lo <b>DQ</b>	<b>A</b> :	Date:	
	R	esolution:	Disposition	on:	_ QA: N/	C Clo	sed:		Date: _	
NCR:		1	WORK ORE	ER NON-CONFORMA	NCE (I	NCR)				
DATE	OTED	Description of NC		Corrective Action Section			Verifi	cation	Approval	Approval
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18										
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#### NOTES:

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1 WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

 RF	잗	HAWKESBURY, ONTARIO, CAVADA	
 CHECKED 11	APPROVED // DRAWING NO.		REV. A
 *	丰	D3438 SHEET 1 OF 1	₩
 DATE		NS STUL	SCALE
 05.05.09		STEP WELDMENT ASSEMBLY	1::
 Α	05.05.09	05.05.09 NEW ISSUE	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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i i				المنطقة			
Part No	:	PAR #: Fault Category:	NCR: Yes	s No DQ	<b>4</b> :	Date: _	

Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC		Corrective Action Section B	Verification	Annrovol	Annual					
		Description of NC Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
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NOTE: Date & initial all entries

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Resolution: